

# Work Order ID 77124

November-25-11 1:42:05 PM

**\*77124\***

Page 1

Item ID: D3639-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 25/11/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 09/12/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3639	Rev A								

100 FLOW WATER JET 0.00  
**\*100\***  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-  
 2024 050 Debur if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control

11/2-3-9

(5)

11/2-3-9

8.2/13/11

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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# Picklist Print

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Page 1

Work Order ID: 77124

**\*77124\***

Parent Item: D3639-3

**\*D3639-3\***

Parent Item Name: Doubler

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	70.1000	0.4277	1.800842			

**\*M2024T3S 050\***

2024-T3 .050 sheet

\*\*

12-3-9

Location

Loc Qty

Loc Code

MAT022

70.1

117684

70.1

117 684

5

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	77124
<b>Description:</b> Doubler		<b>Part Number:</b>	D3639-3
<b>Inspection Dwg:</b> D3639	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.626	✓		V IB02	
Ø0.191	+0.005/-0.001	0.191	✓		V	
Ø0.098	+0.004/-0.001	0.098	✓		V	
0.45	+/-0.030	0.451	✓		V	
1.350	+/-0.010	1.354	✓		V	
2.25	+/-0.030	2.252	✓		V	
3.15	+/-0.030	3.155	✓		V	
4.05	+/-0.030	4.024	✓		V	
4.95	+/-0.030	4.950	✓		V	
5.85	+/-0.030	5.852	✓		V	
6.75	+/-0.030	6.757	✓		V	
7.65	+/-0.030	7.651	✓		V	
8.55	+/-0.030	8.554	✓		PROW30L	
9.350	+/-0.010	9.354	✓		P	
9.45	+/-0.030	9.453	✓		P	
10.350	+/-0.010	10.355	✓		P	
11.25	+/-0.030	11.258	✓		P	
12.15	+/-0.030	12.15	✓		T IB01	
12.85	+/-0.030	BEND	✓		T	
13.86	+/-0.030	13.86	✓		T	
13.96	+/-0.030	13.96	✓		T	
0.805	+/-0.010	0.816	✓		V	
1.00	+/-0.030	0.994	✓		V	
2.100	+/-0.010	2.108	✓		V	
3.30	+/-0.030	3.304	✓		V	
2.000	+/-0.010	2.003	✓		V	
2.590	+/-0.010	2.591	✓		V	

<b>Measured by:</b>	IB	<b>Audited by:</b>	D	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12-3-9	<b>Date:</b>	12/3/09	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.10.24	New Issue	KJ/EC/DD	

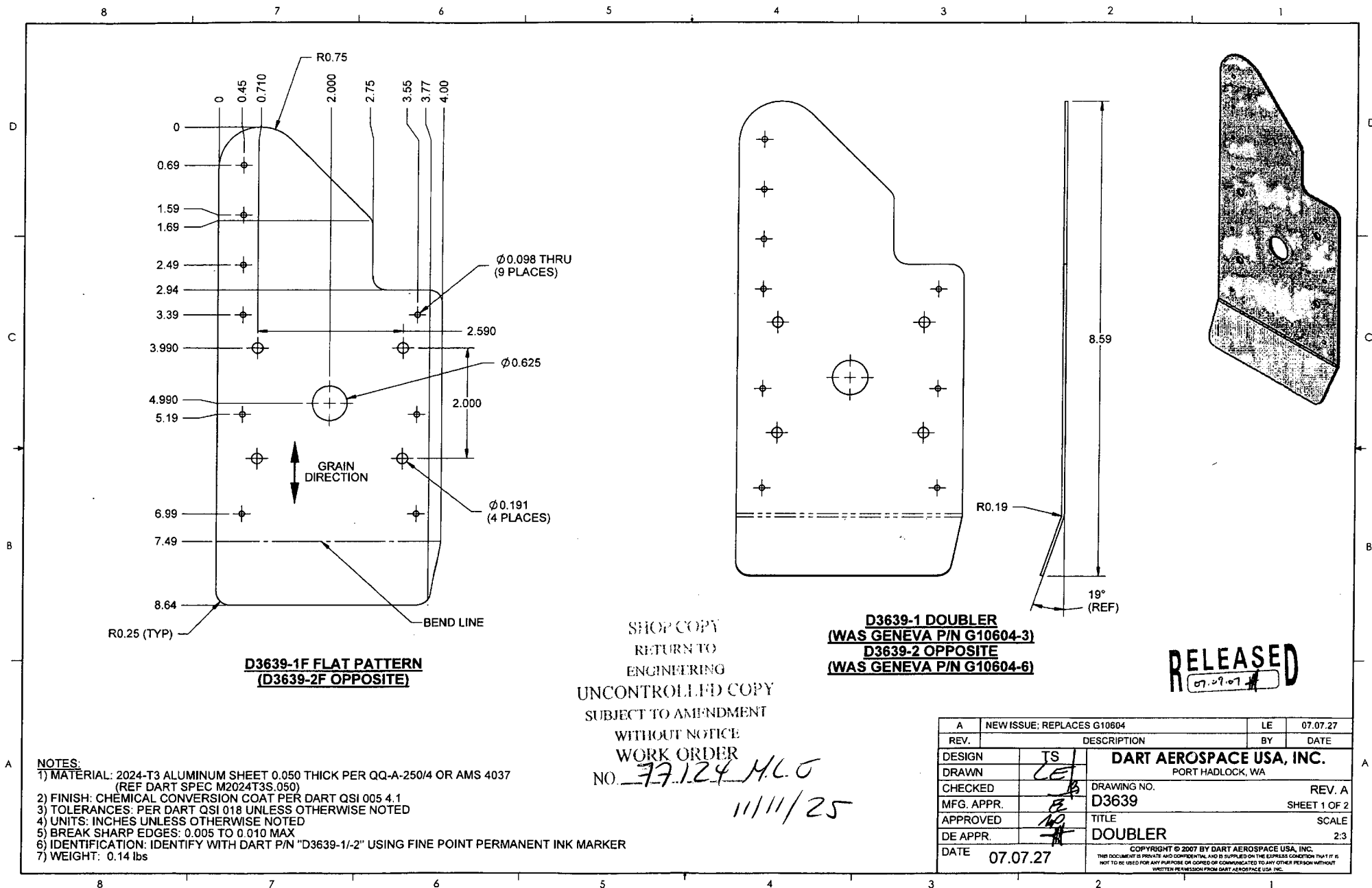
W/O:		WORK ORDER CHANGES					
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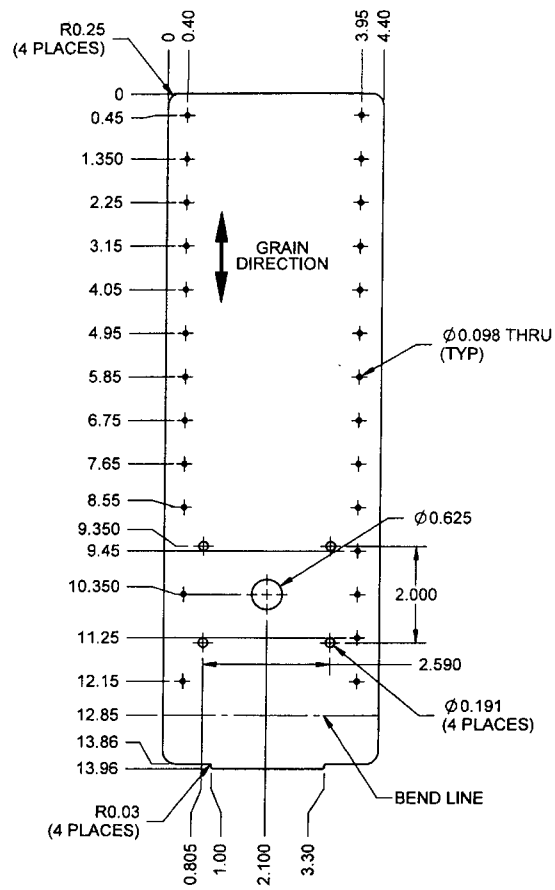
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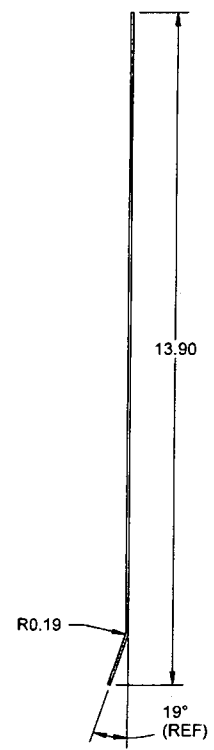
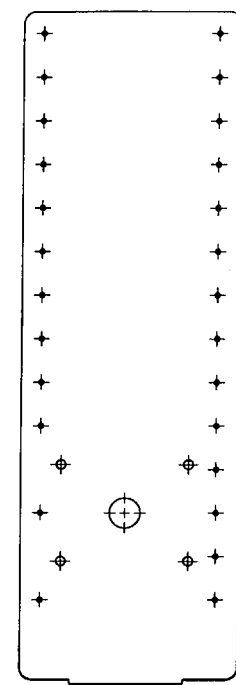
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**D3639-3F FLAT PATTERN**  
**(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER**  
**(WAS GENEVA P/N G10604-4)**  
**D3639-4 OPPOSITE**  
**(WAS GENEVA P/N G10604-5)**



**RELEASED**  
07.09.07 #

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	D3639	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	DOUBLER	2:5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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